

SOLID GOLD RINGS

Some Are Stamped Out With a Die, Some Cut From Tubes.

BUT MOST OF THEM ARE CAST

As a Rule, They Are Formed in Molds of Cuttlefish Bone, Into Which the Pattern Sinks as Though Pressed into Wax—Making the Molds.

Cuttlefish bone is familiar to most people, as it is seen thrust between the bars of a bird cage for birds to peck at. Birds clean their beaks on it, and they like to eat it. But cuttlefish bone has other and more interesting uses. It is used in the manufacture of tooth powder and of polishing powder and in the making of a prepared food for birds, but perhaps the most interesting of its uses is in the making of molds in which to cast gold rings.

Some gold rings are cast in tiny flasks containing molds of fine sand; others are stamped out with a die. Wedding rings are made from a drawn tube of gold in which the rounded outer shape of the ring is produced on a mandrel, the several sections thus formed being then sawed off even when finished and polished to form a perfect ring. But of the vast number of solid gold rings produced by manufacturing jewelers, including rings to be mounted with stones, 75 per cent are cast in cuttlefish bone molds.

Such a mold can be used but once, and so the manufacturing jeweler uses a lot of cuttlefish bone. The molds may be made in two, three, four or five parts, according to the elaborateness of the ring to be molded. The bone serves both as flask and as molding material.

Suppose the molder is to make for a ring comparatively simple in shape a three part mold. He sits at a bench on which he has brass patterns of the rings to be molded. The manufacturing jeweler has hundreds, many hundreds, of these pattern rings, to which he is continually adding designs.

Handy by the molder has a box of cuttlefish bone. Only bone of the finest quality and finest texture is used, and such bone serves for this purpose admirably. Under pressure of an object upon it this bone breaks down perfectly and with no surrounding fractures or fissures. It takes an impression practically as perfect as a plastic material would do, while at the same time it stands up perfectly around the impression made.

The molder takes a cuttlefish bone in its familiar oval shape and with a little sharp toothed saw saws off the tapering sides and the ends, leaving a keystone shaped in cross section. Then straight across he saws off one end of this block about a quarter of its length from the end, and then the larger piece he saws through from side to side midway of its thickness. Now he has the original block of bone divided into three parts.

He rubs the face of each of these parts perfectly smooth on a metal plate set before him conveniently in the bench, and then the material is ready for use as a mold. The molder turns one of the two bigger blocks over on the bench with the smooth surface up and picks up the model ring, and with a deft, sure touch he presses this model down for half its thickness all around into the delicately fragile but evenly textured bone—this in the case of a three piece mold at one end of the block, leaving the head or top of the ring projecting beyond the end edge. Next he picks up the other half of this block, turns its smooth face down and presses that down upon the ring as it lies with half its thickness projecting above the surface of the lower block, and now he has a mold of the ring complete except for the projecting head.

At this stage he picks up that end piece of the bone that he had sawed off and presses that with its smooth face down upon the ring's head, so taking an impression of that, and then he has the mold complete, but with the model ring inside of it.

Now he scores lightly this model outside, across its side edges, and he scores lines from the top block to the sides, so that when he has taken the mold apart he can put it together again precisely as it should be, and then he opens it and takes out the pattern, and if anywhere the molded form should require a touch of smoothing he does that, and then, beginning small and opening out wider, he cuts out in the inner sides of the two halves of the big block from the bend of the ring mold out to the end of the block an opening, the gate, through which the molten gold will be poured when the ring is molded. Then he puts the pieces of the mold together again and binds them with soft wire, and there's your cuttlefish bone mold perfect and complete.

Sometimes they bind half a dozen or a dozen of such molds together and cut little channels inside from the gate to each one of the separate molds within, and then when they pour the gold they mold half a dozen or a dozen rings at once.—New York Sun.

Craft Wins.
"How did you ever manage to get on the good side of that crusty old uncle of yours?" asked Fan.

"Fed him the things he liked when he came to visit us," replied Nan. "The good side of any man is his inside."—Chicago Tribune.

Gratitude is a subtle form of revenge. The receiver of a benefit recovers his superiority in the effort to be grateful.—John Davidson.

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Cookery Points**Winter Salad.**

Salads for winter, whether served with roast meat or game, are an important branch of the cold weather cuisine. Salads can be made from most of the ordinary winter vegetables—cauliflowers, celery, beet root, tomatoes, cabbages, etc., and there are also available corn salad and the German salad potatoes, the latter of which are prepared in the same way as a potato salad.

Corn salad is often eaten without any garnish, as it has a delicate flavor of its own. It is at its best, however, when prepared with beets, but only a simple dressing should be used.

The beet is a very valuable winter salad vegetable. It is added as a garnish to most salads and can itself form the basis of a most delicious salad.

A favorite French beet salad is made as follows: Cut up a boiled beet into thin slices and steep in vinegar, pepper and salt for a little while. Prepare in the same way some potatoes, a few celery roots and, if liked, a few truffles.

Season the whole with salt, pepper, oil and vinegar and a little chopped gherkin, chervil and tarragon. Before serving the salad should be well drained and a good mayonnaise poured over it.

Colonial Apple Pie.

Sift one and one-fourth cupsful of flour with one teaspoonful of baking powder and one of salt. Place in a bowl and put into the mixture one-half cupful of cold lard. Beat one egg and add it together with sufficient ice-water to make a stiff dough. Chill, divide into two parts and line a deep pie pan with one part, allowing the paste to hang over the edge of the pan about an inch. Fill the prepared pan with thinly sliced apples, heaping them up. Cover with a covering of pie paste cut so as just to reach the edge of the pan. Now fold the lower crust up over the top one and press firmly together. Prick with a fork and bake in a moderate oven an hour. When cool cut around the edge with a sharp knife. Remove the upper crust, mash the apples fine and season with butter, sugar and cinnamon. Replace the top crust and serve with sweetened cream.

As the trip is very tender it should be boiled as soon as it comes from the market. The pickled tripe is liable to be very sour, and many people prefer to use the fresh honeycomb tripe and add some acid condiment.

Drain the tripe and wipe dry; brush the crinkled surface with melted butter and sprinkle fine cracker dust over the top. If impossible to wipe dry, lay it first in the cracker dust.

Lay it in a greased wire broiler and cook the plain surface until it is warmed through, about four minutes, then turn and cook the crinkled surface until a delicate brown. Be careful not to burn it, as the crumbs scorch easily. Slip it off on a hot platter, crumb side up, and spread with maitre d'hotel butter. Garnish with lemon and watercress.

Escaloped Oysters.

Take two quarts of oysters. Wash them and drain off the liquor. Roll some crackers (not too fine), put a layer of oysters into a pan, cover with a layer of crumbs, some bits of butter and a little pepper and salt, then a layer of oysters, and repeat until the dish is full. Have cracker crumbs on the top. Turn a cupful of oyster liquor over it, add good sweet milk sufficient to saturate it thoroughly and bake three-quarters of an hour.

Coffee Fruit Cake.

One cup of molasses, a cup of brown sugar, a cup of butter, a cup of raisins, a cup of English currants, an egg, a cup of coffee (left over), a teaspoonful of soda, a teaspoonful each of cloves, cinnamon and allspice, four cups of flour. Mix well and bake an hour in a slow oven. This quantity makes one large cake or enough for six meals in a family of five. It is improved by the addition of two eggs.

Sponge Cake For Children.

One and a half cupsful of pastry flour, two teaspoonfuls of baking powder or one teaspoonful of soda and one-half teaspoonful of cream of tartar. Add two eggs broken into a cup, then fill up with thin cream and one cupful of sugar. Stir all together in a mixing bowl, flavor with lemon or vanilla. The secret is in the beating, five minutes or more.

Grapefruit Cocktails.

Peel the grapefruit and remove the flesh of each section from the tough skin that divides them. Place each portion in a sherbet or a cocktail glass and pour over them the juice of maraschino cherries or pineapple sirup. Garnish with a cherry and serve ice cold.

Concerning Turnips.

Turnips are useful in soups. They give the stock a good flavor. Turnips contain a substance which gives the soups in which they are cooked a gelatinous consistency when cold. Yellow turnips ought to be boiled about two hours.

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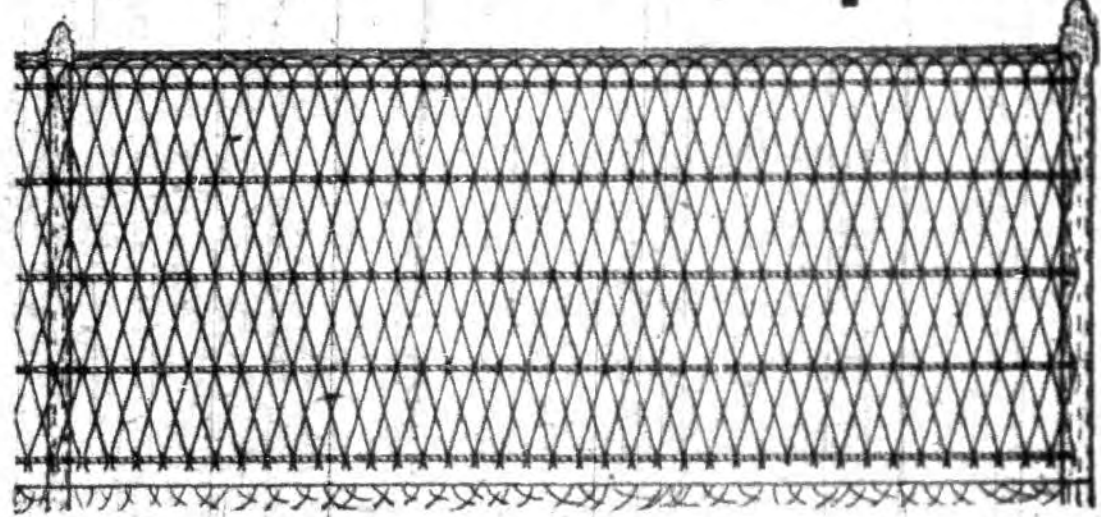
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